

Sprint

Work Order ID 62494-1

Thursday, September 30, 2010 2:31:46 PM



Page 1

Item ID: D3909-041

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Assembly, Fwd

Stop



Start Date: 9/30/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Bf

Date: 10-9-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3909

C

100



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

gB10/12/14 O

110



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg
Trim rivet to 1.185" long

gB10/12/14 O

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S10/12/15

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62494

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Identify as per dwg & Stock Location:

0.00

Packaging

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, September 30, 2010 2:31:51 PM

Page 1

Work Order ID: 62494



Parent Item: D3909-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010

Required Date: 9/30/2010

Comments: IPP RevA: New issue DD verified by:EC
per dwg revB DD 10.04.20 verified by:EC

JPP Rev.B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2690-6 Manufactured No 100 Each 31.0000 1 6

Lanyard Assembly

Lanyard Assembly

D3909-1



Lug Plate, Fwd Crosstube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
ST095	15		
57824	8		
59155	7		

D3909-3

Fwd Lower Attach Arm

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST095	13	
59209	1	
59442	12	

D3909-4



Everbolt Stud.

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST095	1	
58240	1	

W/O:		WORK ORDER CHANGES							
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Page 2

Work Order ID: 62494



Parent Item: D3909-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010

Required Date: 9/30/2010

Start Qty: 6.00

Required Qty: 6.00

D3910-1



Crosstube Lug

Manufactured

No

100

Each

9.0000

2

12

E/P 10/11/29
B62009 (4x)

1

B62944 (6x)

12

B64106 (1x)

E/P 10/11/29

B60170 (12x)

D3917-1



Washer

Manufactured

No

100

Each

72.0000

2

AN3C12A



Bolts

Purchased

No

100

Each

62.0000

4

24

E/P 10/11/29

M116022 (24x)

AN3C13



Bolt

Purchased

No

100

Each

70.0000

1

6

E/P 10/11/29

6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 62494



Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010

Required Date: 9/30/2010

Start Qty: 6.00

Required Qty: 6.00

X MS17984-C413

Purchased

No

100

Each

18.0000

1

6

PIN, QUICK RELEASE



Location	Loc Qty	Loc Code
----------	---------	----------

ST297	4	
-------	---	--

114340	4	
--------	---	--

ST314	14	
-------	----	--

114523	1	
--------	---	--

114886	13	
--------	----	--

EBro/11/29

M116081

(5x)

M116304(12)

X MS20615-4M120 4M118

Purchased

No

100

Each

266.0000

3

18

RIVET



Location	Loc Qty	Loc Code
----------	---------	----------

ST323	266	
-------	-----	--

114808	96	
--------	----	--

115054	170	
--------	-----	--

EBro/11/29

M115037

(18x)

AN310C3

Purchased

No

100

Each

70.0000

1

6

Castellated Nut



Location	Loc Qty	Loc Code
----------	---------	----------

ST349	70	
-------	----	--

114304	20	
--------	----	--

114714	50	
--------	----	--

6

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, September 30, 2010 2:31:51 PM

Page 4

Work Order ID: 62494



Parent Item: D3909-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010

Required Date: 9/30/2010

MS21043-3



Purchased

No

100

Each

2,599.000

4

24



Nut

Location	Loc Qty	Loc Code
FG	76	
103691	76	
ST301	2523	
111383	46	
112314	2477	

E9/10/11/29

MS24665-151



Purchased

No

100

Each

617.0000

1

24



Cotter Pin

Location	Loc Qty	Loc Code
ST309	617	
17566	617	

E9/10/11/29

NAS1149C0332R



Purchased

No

100

Each

443.0000

8

48



Washer

Location	Loc Qty	Loc Code
ST297	443	
113524	10	
113737	150	
115000	125	
115698	158	

E9/10/11/29
M115832 48x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 5

Thursday, September 30, 2010 2:31:51 PM

Work Order ID: 62494



Parent Item: D3909-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010

Required Date: 9/30/2010

NAS1149C0363R

Purchased

No.

100

Each

5,838.000

2

12



Washer



Location	Loc Qty	Loc Code
ST297	5838	
113524	188	
113644	150	
113889	500	
114742	5000	

9/30/11/2010
12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

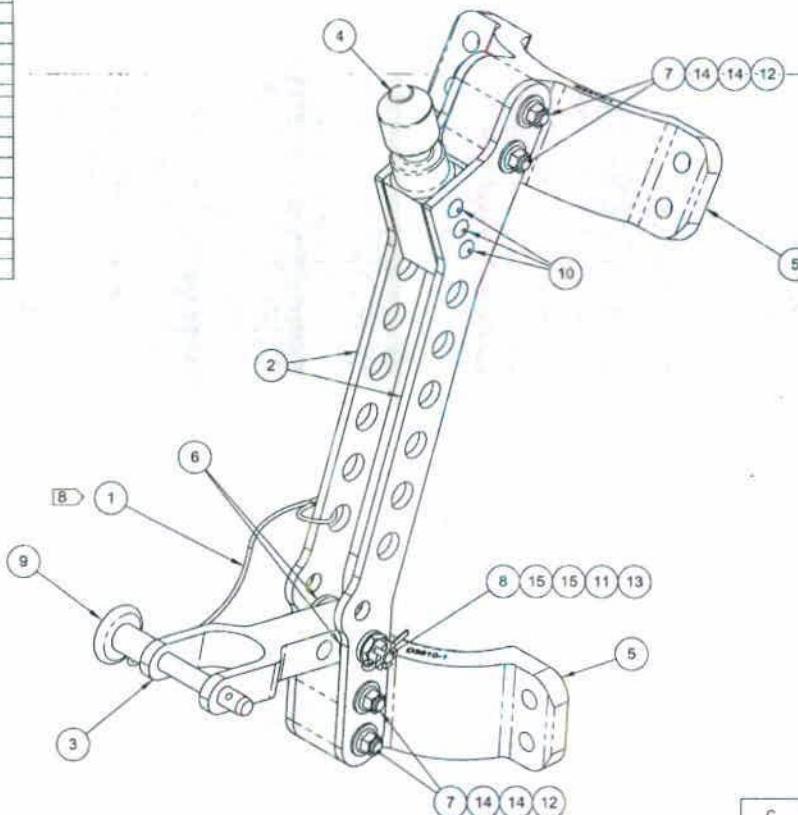
4

3

2

1

ITEM	QTY	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.81 lbs
- 8) ATTACH D2690-6 TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. ~~62494~~
880-9-30

RELEASED
2010-08-04
JPH

C	ITEM #4: 1.50 WAS 1.30 (ZN B5-5), 2.88 WAS 2.68 (ZN B6-5); WEIGHT AFFECTED (D3909-041-5).	MB	10.06.18
B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED. ITEM 14 QTY 2 WAS 10. SHT 5. D3909-5 REVISED: SECTION A-A & DIM Ø0.650 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220, R0.06 WAS R0.05. WEIGHT REVISED.	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. C	
MFG. APPR.		DRAWING NO.	
APPROVED		D3909	SHEET 1 OF 5
DE APPR.		TITLE	SCALE
DATE	10.06.18	FWD X-TUBE LUG ASSY	NTS

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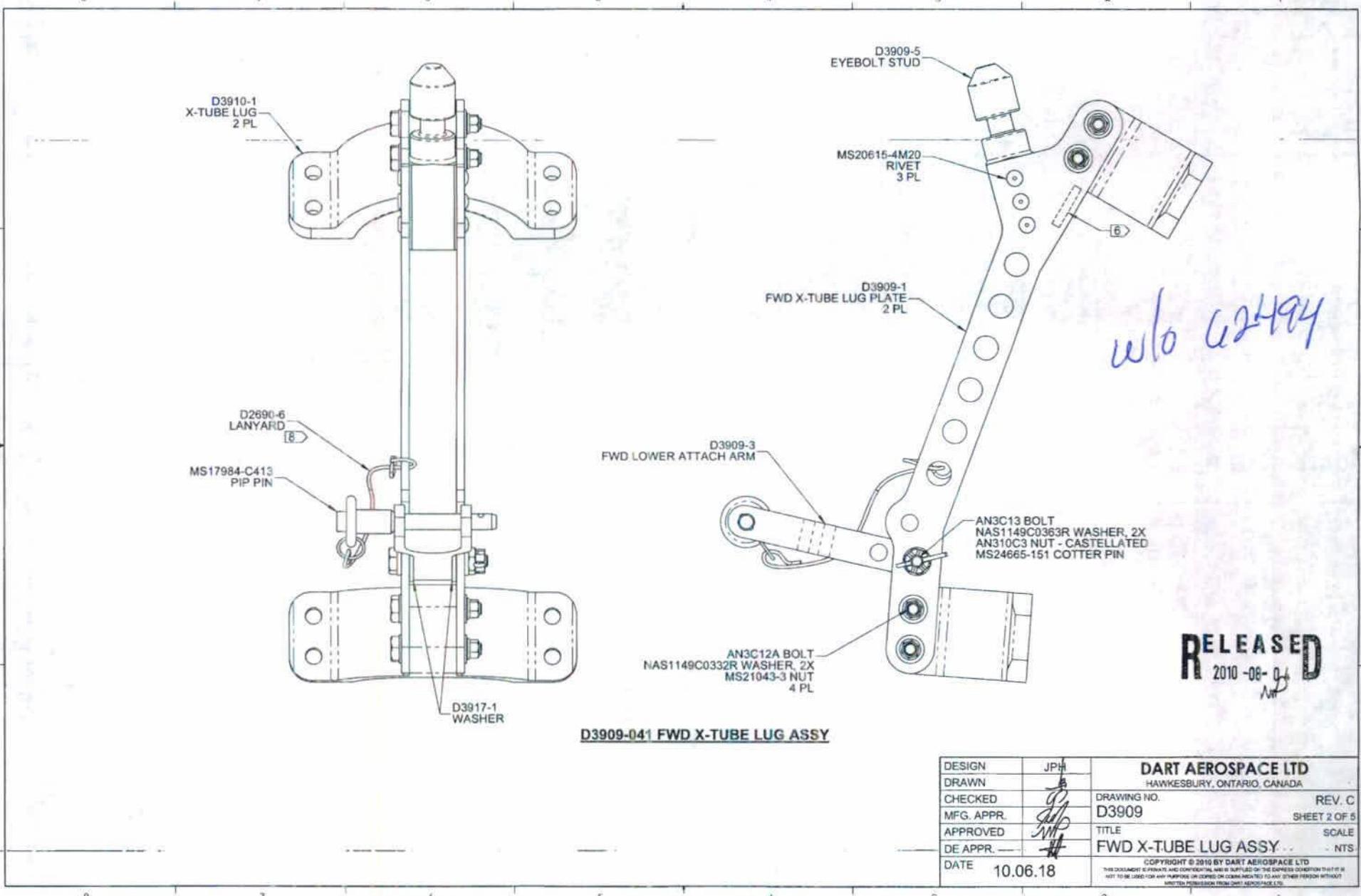
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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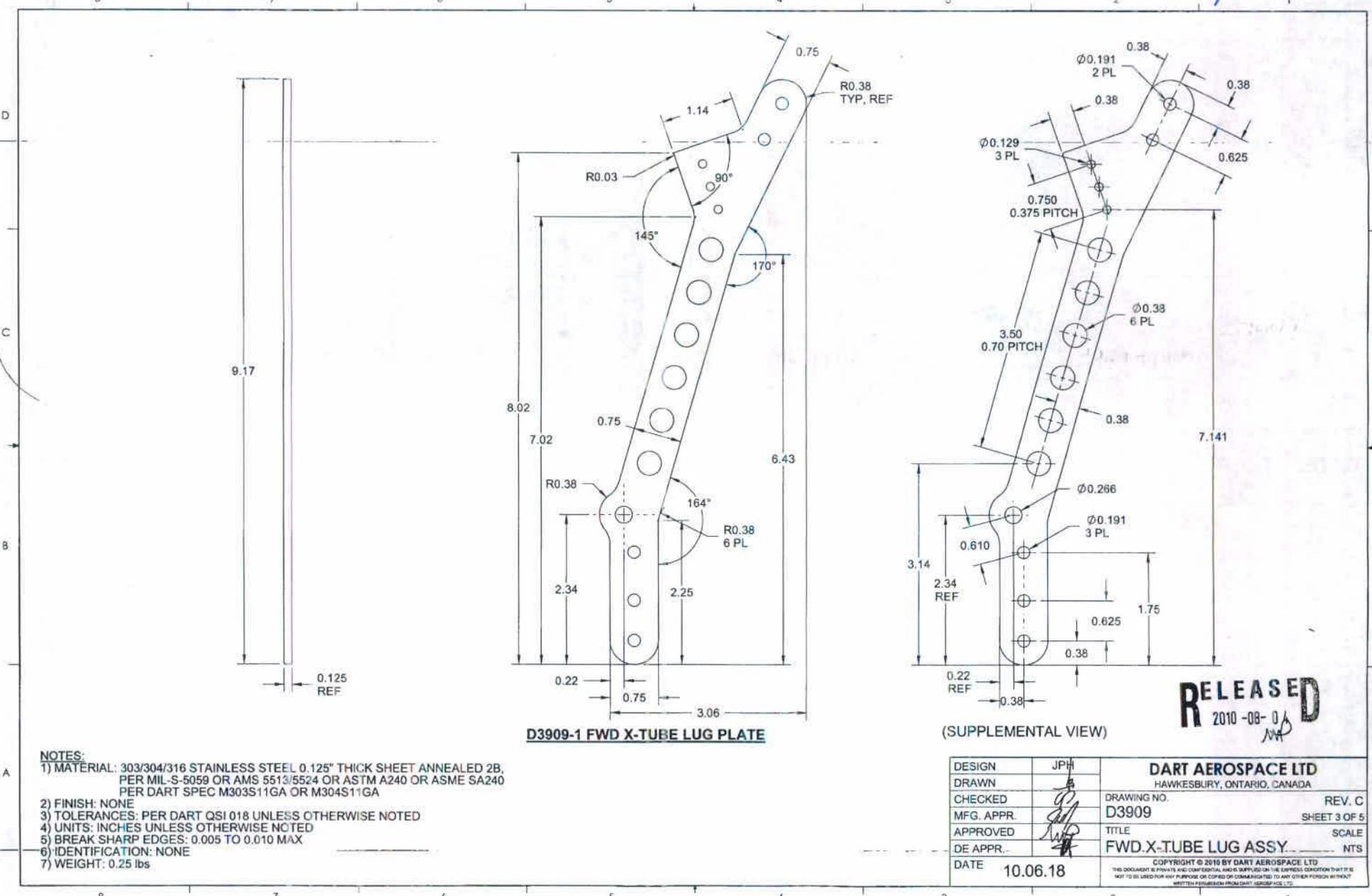
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NOTE: Date & initial all entries

wto 62494



W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

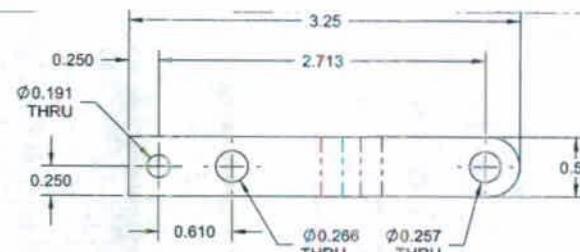
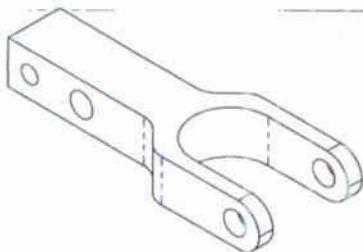
D

C

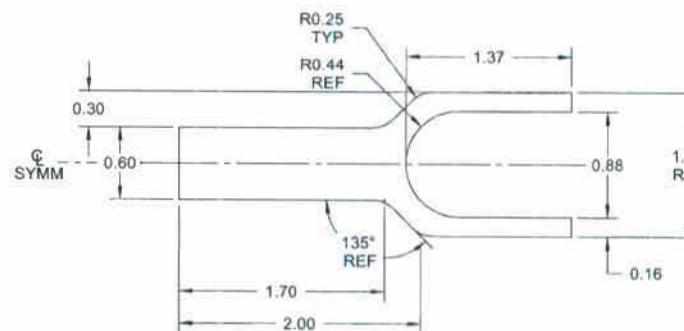
C

B

B



WB 62494



D3909-3 FWD LOWER ATTACH ARM

RELEASED
2010-08-06
MM

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A582 OR ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

8

7

6

5

4

3

2

1

DESIGN	JPH	DART AEROSPACE LTD
DRAWN	6	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>JG</i>	DRAWING NO.
MFG. APPR.		REV. C
APPROVED	<i>JG</i>	D3909
DE APPR.	<i>JG</i>	SHEET 4 OF 5
DATE	10.06.18	TITLE
		FWD X-TUBE LUG ASSY
		SCALE NTS

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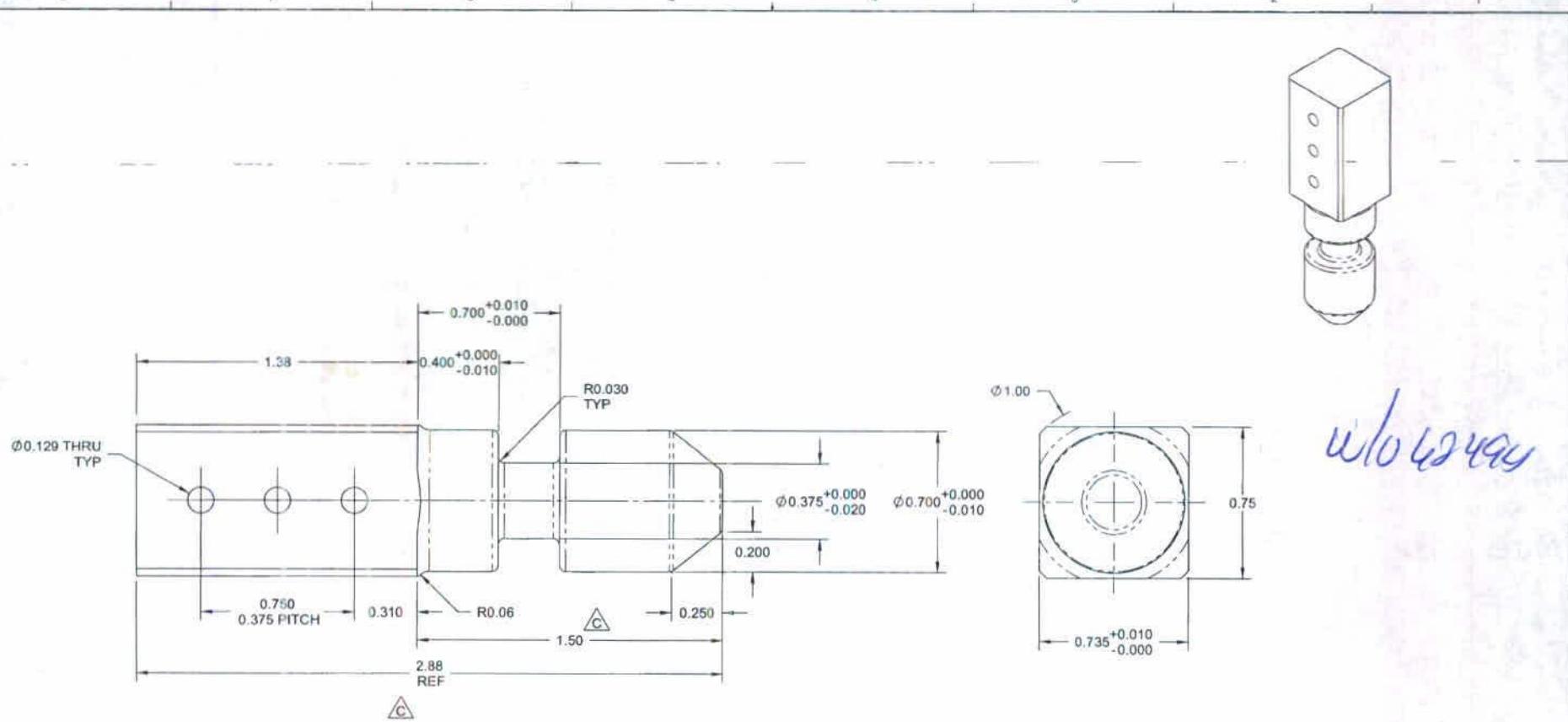
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3909-5 EYEBOLT STUD

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR PER ASTM A582 OR ASTM A276
PER DART SPEC M303R OR M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

DESIGN	JPH	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. C
MFG. APPR.	<i>[Signature]</i>	D3909 SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE
DE APPR.	<i>[Signature]</i>	SCALE NTS
DATE	10.06.18	FWD X-TUBE LUG ASSY

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RELEASED
2010-08-04
[Signature]

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